

Date: Wednesday, 9/27/2006 11:09:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 28738A		Part Number	: D30651		
Estimate Number	: 10375		Drawing Number	: D3065 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/27/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 9/27/2006 Type : SMALL /MED FAB		Due Date	: 10/10/2006 Qty: 60 Um: Each		
Previous Run	: 27590A					
Written By						
Checked & Approved By						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF					
	: Est:D 06.04.25 Water jet		EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 0.1300 sf(s)/Unit Total : 7.7994 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: M10295 <i>M 06 09 28</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <i>B</i> <i>M 06 09 28</i> Prog Rev: <i>B</i>		
2-Deburr as required		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>J 06-09-02 61</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <i>S&D 06/10/02 60</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/02	5.0	Part scrap. Found with 4 holes out of line.	<u>J</u> <u>asenq</u>	Scrap = destroy, no Replace.	SAD 06/10/02	<u>J</u> <u>asenq</u> 06-10-02	<u>J</u> <u>asenq</u>	<u>J</u> <u>asenq</u> 06-10-02

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE <i>SPS 06/11/09</i> <i>MF. 06/10/16</i>
7.0	QC5	INSPECT WORK TO CURRENT STEP <i>DA 06/11/09 (60)</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>9LFC 06/11/15 260</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>MF. 06-11-18</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>MF. 06-11-18</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE <i>DP 06/11/20</i>

Job Completion



WOB (1.10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28738A
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

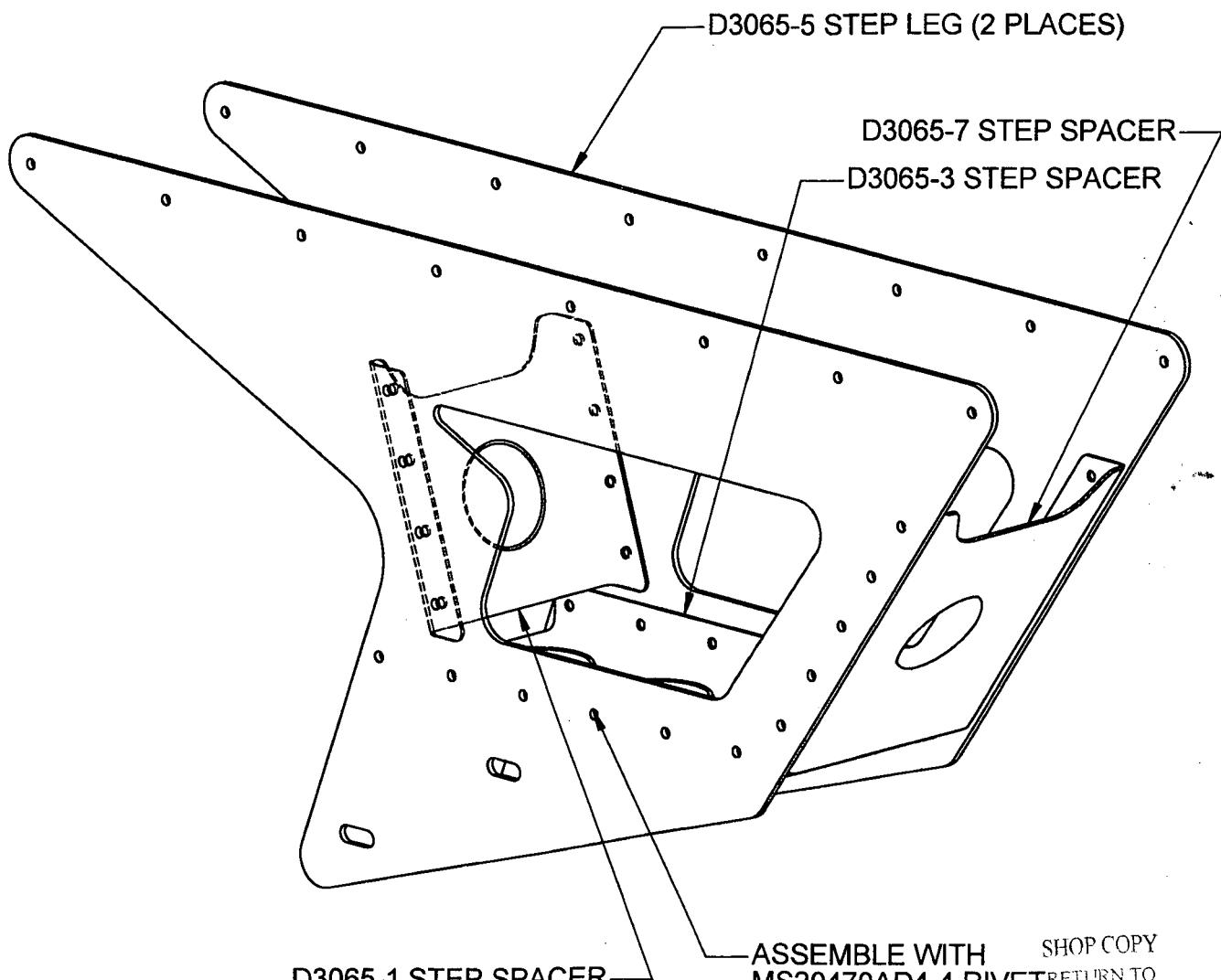
X First Article Prototype

Measured by:	<i>M. M.</i>	Audited by:	<i>J.</i>	Prototype Approval:	
Date:	<i>10/22/02</i>	Date:	<i>10/22/02</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY**

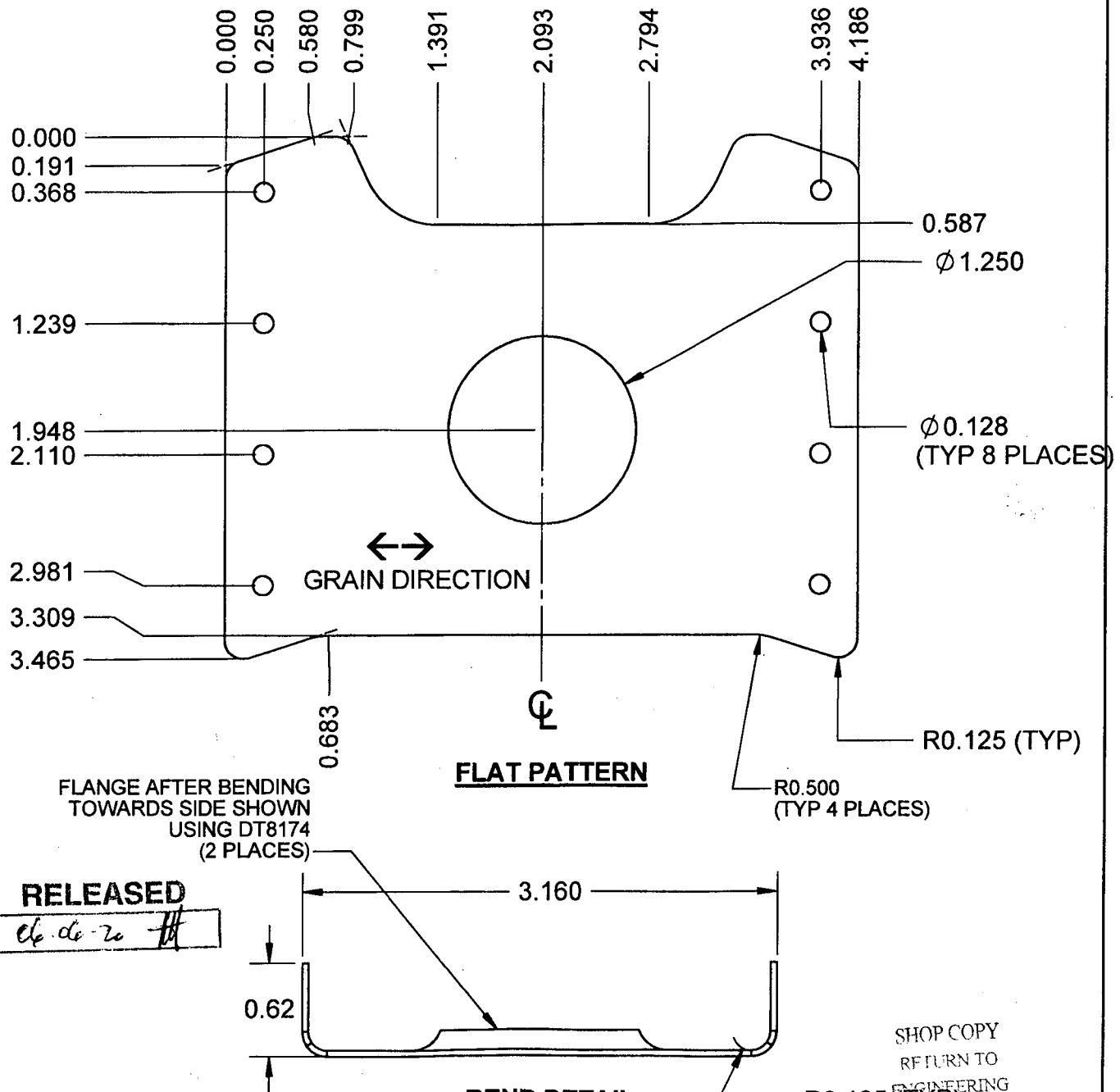
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040) AMENDMENT
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

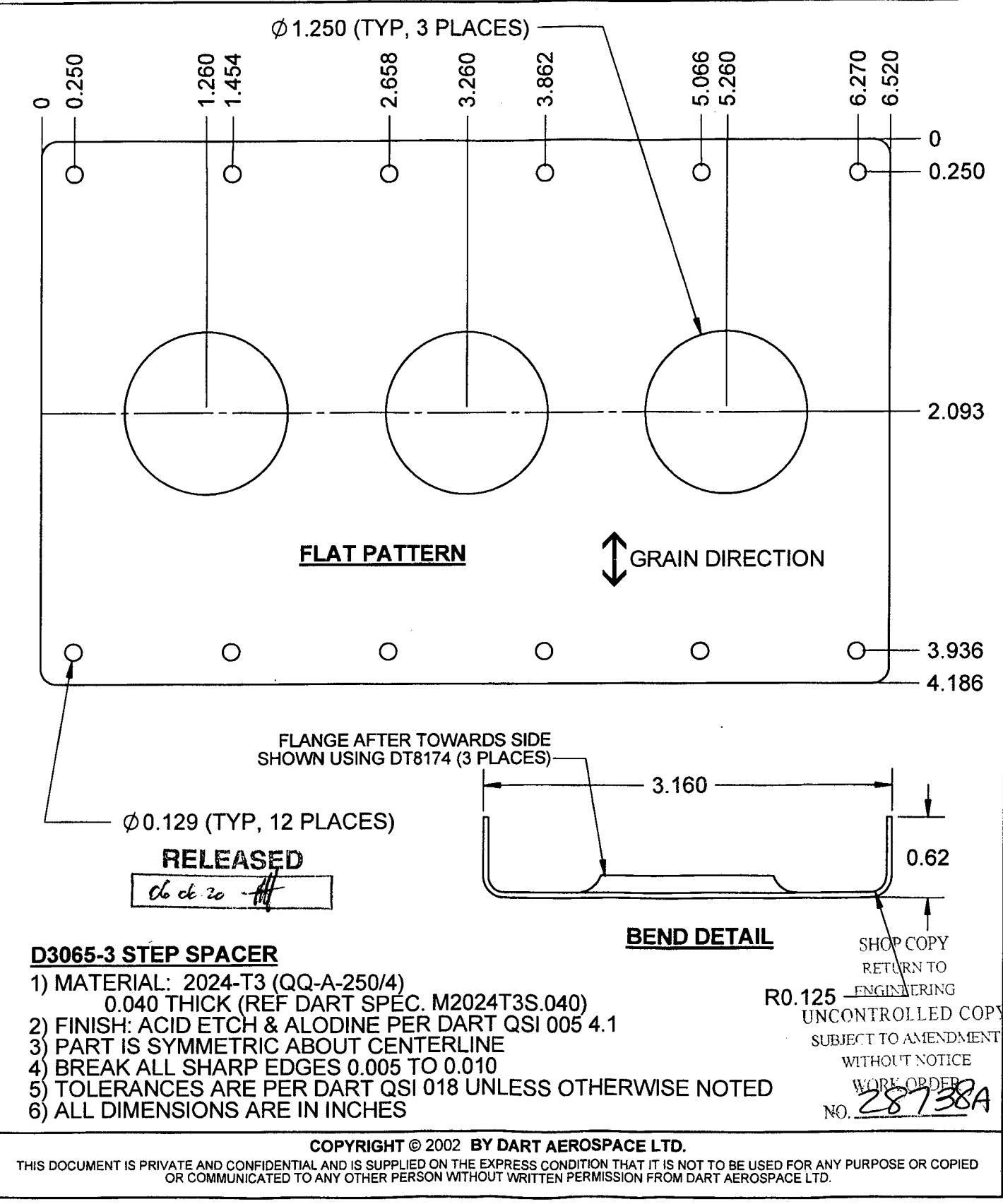
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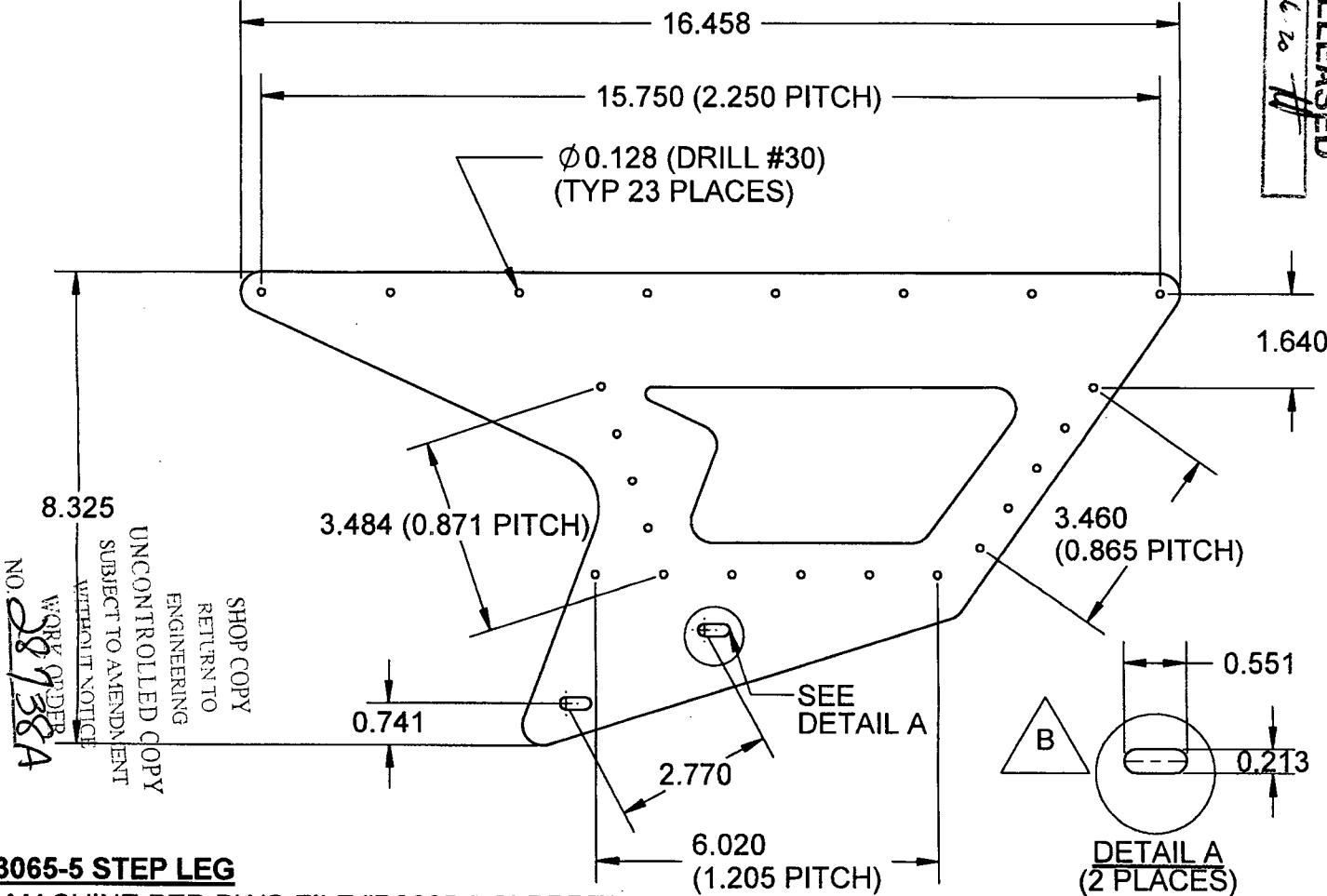
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	



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PH	PH	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

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D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

